

Work Order ID 162768

162768

Page 1

Monday, June 12, 2017 12:41:49 PM

Item ID: D3947-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Panel , Upper LH Post (Sub-Comp D350-766-015)
Start Date: 6/19/2017 Start Qty: 3.00 *3* Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 3.00 *3* Customer:
Reference: SCHEDULED/C
Approvals: Process Plan:  Date: JUN 12 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3947	A

110	THERMOFORMING MACHINE	0.00				3	JUN 28 2017	DAS 13 9-99
-----	-----------------------	------	--	--	--	---	-------------	-------------------

110
Purchasing Memo
Purchasing ISSUE P/O: 36858
SUPPLIER: PLASTECH
MANUFACTURE D3947-1 AS PER DWG
C OF C IS REQUIRED

140	Receive & Inspect for Damage & Mat'l Certs	0.00
140	HAND FINISHING THERMOFORMING	
Packaging	Memo	0.00
Packaging		

3x 807-7-10

*145
SMALL FAB

TRIM To DWG

DAS
07
9-99
17/07/19

DQA:

Date: 2017-07-25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: JUL 24 2017

Work Order update only ☐

Work Order: 162768 Part No. D3947-1 NCR No. 17-6553		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☒																																											
Date: 7/7/17		Step #: 110		QTY Effective: 3		MRB (QSI042) Approval DAS 12 9-89 7/7/17																																									
Description Work Order Deviation				Disposition																																											
Edge was trimmed 1.3" instead of 1.8"				Acceptable. Sufficient edge for overlap and adjustment by customer																																											
				Completed By DAS 12 9-89 7/7/17 Lead hand / Supervisor Approval Verification DAS 38 9-89 JUL 20 2017 QC / QA Coordinator Approval DAS 38 9-89 JUL 20 2017																																											
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☒ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☒ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☒ Outside Dimensions</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>						☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☒ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong																																												
☐ Bending	☐ Set-up	☐ Folio/Program	☒ Outside Dimensions																																												
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance																																												
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect																																												
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																												
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved																																												
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing																																												
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish																																												
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																												
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																												
OTHER: supplier																																															

Work Order ID 162768

Monday, June 12, 2017 12:41:49 PM

162768

Page 2

Item ID: D3947-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel , Upper LH Post (Sub-Comp D350-766-015)
Start Date: 6/19/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				3			DAS 38 JUL 20 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>51427</u> Memo	0.00 0.00				3			DAS 21 JUL 20 2017
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/7/20 JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Monday, June 12, 2017 12:42:00 PM

Page 1

162768

D3947-1

Required Qty: 3.00

IPP RevB
IPP REV:C 17.06.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3947-1P		Purchased	No			110	Each	0.0000	1	3			

D3947-1 P

Panel , Upper LH Post (Sub-Comp D350-766-015)

3x SP 17-7-10

DQA: _____ Date: _____

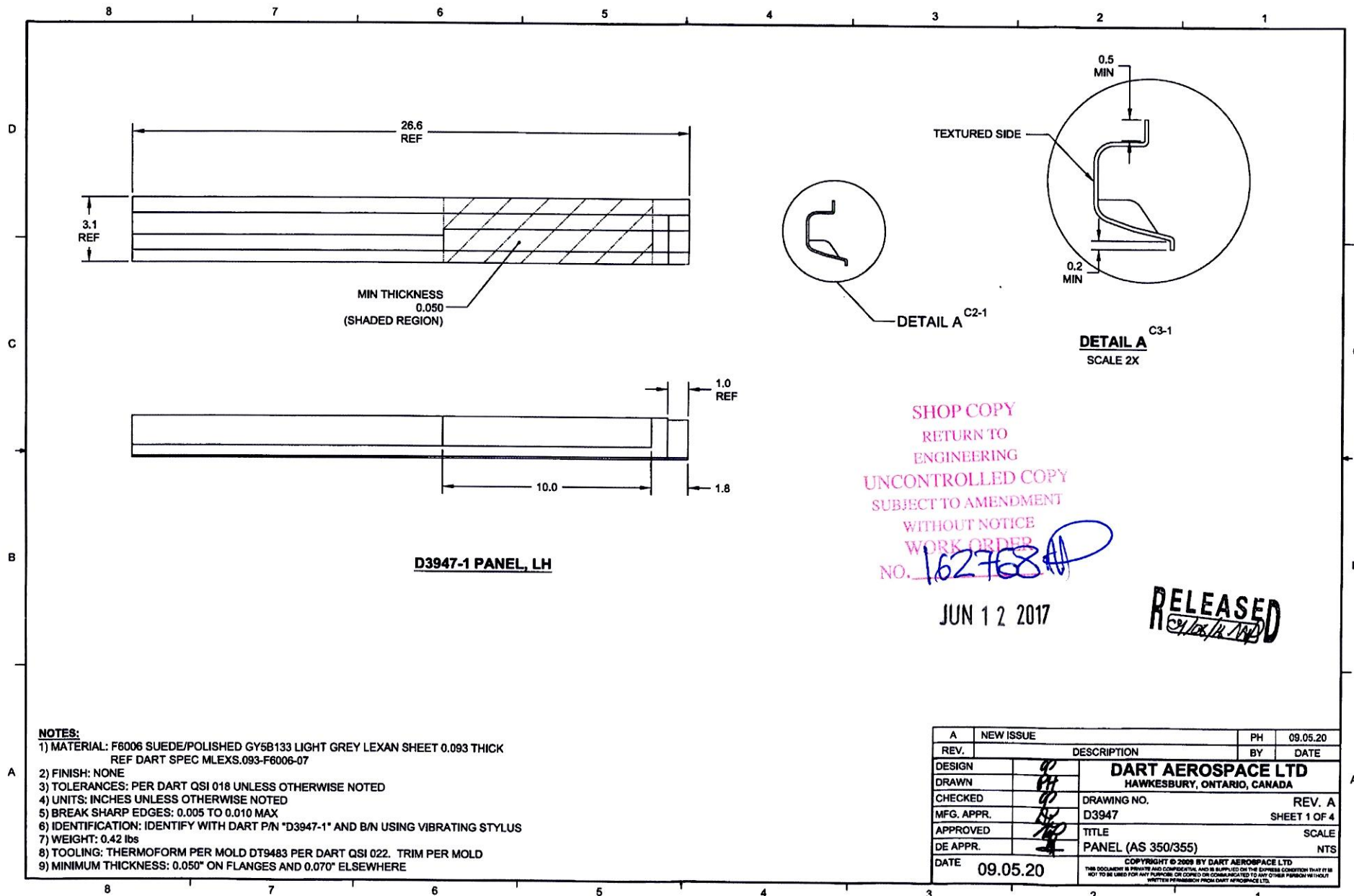


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162768

JUN 12 2017

RELEASED
2/12/17

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

A NEW ISSUE		PH	09.05.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3947
TITLE PANEL (AS 350/355)
REV. A
SHEET 1 OF 4
SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36858**

Purchase Order Date 6/28/2017

PO Print Date 6/28/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 60
Currency CAD
FOB Destination-Collect

3	D3947-3P	Panel , Lower LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162770

Line Total: \$255.00

4	D3947-2P	Panel , Upper RH Post (Sub-Component D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DWG D3947 REV. A
B162769

Line Total: \$255.00

5	D3947-1P	Panel , Upper LH Post (Sub-Comp D350-766-015)	7/5/2017	FN	3.00	\$85.00	\$255.00
			Yes		Each		
			7/5/2017				

AS PER DFWG D3947 REV. A
B162768

6/17-7-10

Note:

6/28/2017

Ship Date: 07/06/2017

Pick Ticket - 23194

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: CHANTEL LAVOIE
O

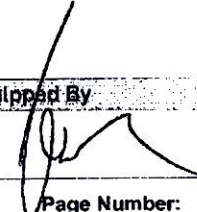
S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: CHANTEL LAVOIE
O Email: clavoie@dartaero.com
Tel: (613) 632-5200

Purchase Order	Sales Order	Incoterms	Payment Method
PO36858	SO-019079		COL
Carrier Account #	Ship Via	Tracking Number	
	FREIGHTCOM INC. -		
Payment Terms	Account Status		
NET 60	Active		

Item Number - Revision	Description	Quantity To Ship	UOM
CUSTOM -	SETS GREY POLYCARBONATE KIT Shipment Date: 7/6/2017 D3946 / D3947 SERIES HS Code: 8708.8.1000 - Country of Origin : CA	3 <u>3</u>	EA

1 PC D3946-1P
1 PC D3947-4P
1 PC D3947-3P
1 PC D3947-2P
1 PC D3947-1P ✓

8817-710

Number of Containers	Gross Weight	Shipped By
		

DART AEROSPACE LTD		Work Order: 162768
Description: Panel, Upper RH		Part Number: D3947-2
Inspection Dwg: D3947	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DAS</u> 07 9-89	Date: 17/07/19
--	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.0"	✓			
0.2	Min	0.3"	✓			
0.5	Min	0.5"	✓			
1.8	Min	1.3"	✓			
3.1	REF	3.3"	✓			
26.6	REF	26.75"	✓			
0.050	Min	0.064	✓			
0.070	Min	0.074	✓			

Measured by: <u>DAS</u> 07 9-89	Date: 17/07/19
Audited by:	Date:
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	